

# Work Order ID 51640

August 27, 2009 8:28:31 AM



Page 1

Item ID: D3578-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Doubler

Start Date: 8/27/09 Start Qty: 30.00



Cust Item ID:

Required Date: 9/04/09 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

*RS*

Date: *09-8-27*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3578

Rev A

110

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1) Dwg Rev: *A* Prog  
Rev: *A* 12-Deburr if necessary

*EB 09/09/02* (110)

*B 9-9-2*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*B 9-9-2*

(110)

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*EB 09/09/02*

*count*

(110)

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3578-041

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Start Qty: 30.00



Cust Item ID:

Required Date: 9/04/09

Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

0.00

0.00

09/09/03 (110)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

⇒ 8/20/03

conf (H10) f

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

Memo

0.00

0.00

MD 09/09/08

(X110)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Work Order ID 51640

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Page 3

Item ID: D3578-041

Revision ID: A

Item Name: Doubler

Start Date: 8/27/09

Start Qty: 30.00

Required Date: 9/04/09

Req'd Qty: 30.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

JS 09/09/08 (X110) P

170



Small Fab

Small Fab

Small Fab

Memo

1-Assemble as per dwg D3578

0.00

0.00

JS 09/09/22 (110)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 09/09/22

count (X110) P

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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# Work Order ID 51640

August 27, 2009 8:28:31 AM



Page 4

Item ID: D3578-041

Revision ID: A

Item Name: Doubler

Start Date: 8/27/09

Start Qty: 30.00

Required Date: 9/04/09

Req'd Qty: 30.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190



Packaging

Packaging

Identify as per dwg & Stock Location: 244A

0.00

Memo

0.00

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

9/9/09 (110x) SJ

09/09/22 HJ

MF 09-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



# Picklist Print

August 27, 2009 8:28:30 AM

Page 1  
2

Work Order ID: 51640

Parent Item: D3578-041RevA

Parent Item Name: Doubler

Comments:

Start Date: 8/27/09

Required Date: 9/04/09

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3569-1RevA		Manufactured	No			110	Each	22.0000	30.0000			
Decal												



?

Warehouse  
Location

Main Warehouse  
ST  
32084

*N*  
*A* *mf 09-09-22*

Loc Qty

Loc Code

MS20426AD3-3

Purchased

No

110

Each

7,486.000

60.0000



Rivet

Warehouse  
Location

Main Warehouse  
ST

Loc Qty

7486

1563

0

19099

4776

7681

2710

*09/09/22*

*220* *10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

August 27, 2009 8:28:30 AM

Work Order ID: 51640

Parent Item: D3578-041RevA

Parent Item Name: Doubler

Comments:

Start Date: 8/27/09

Required Date: 9/04/09

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			170	sf	270.4990	0.2211	8107		
										RB	9-9-2	
6061-T6 .080 Sheet												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT	270.499
107904	0.02
110254	2.5
110630	42.9353
112040	0.0437
112141	33
112512	192

\_\_\_\_\_  
\_\_\_\_\_  
110630  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_

MS21075L3	Purchased	No			170	Each	123.0000	30.0000				
Nutplate												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	123
109068	12
109371	39
110704	37
111477	15
112314	20

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
13  
70  
27

M112640  
M112690

August 27, 2009 8:28:30 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

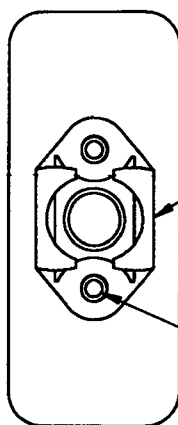
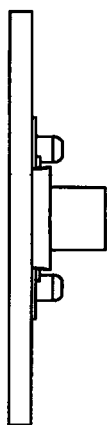
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3578</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.12</b>	TITLE <b>DOUBLER</b>		SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



D3578-1 PLATE

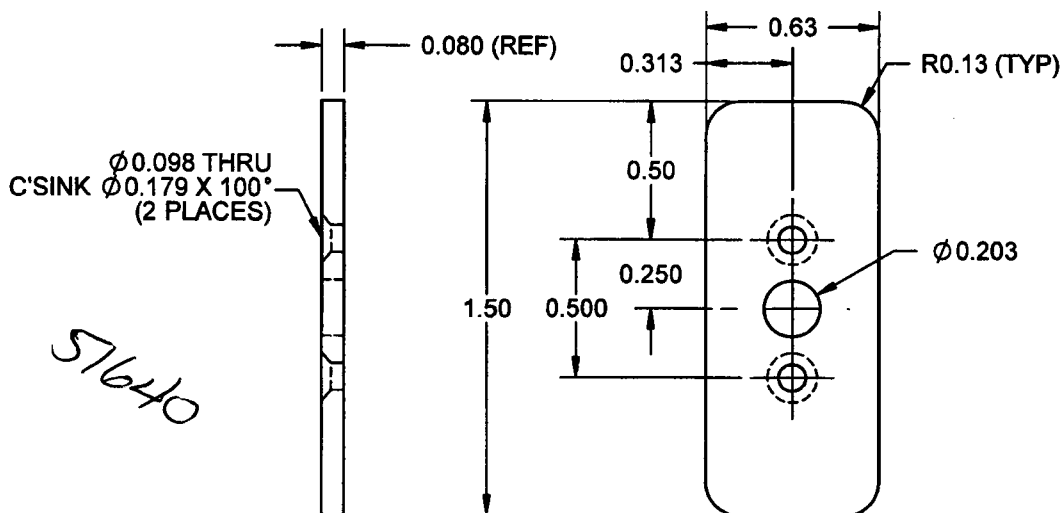
MS21075L3 NUT PLATE

MS20426AD3-3 RIVET  
(2 PLACES)**RELEASED**  
07.04.02**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

**D3578-041 DOUBLER****D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER

**D3578-1 PLATE****D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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